

Work Order ID **165878**

Friday, September 01, 2017 11:25:17 AM

165878

Testing

Page 1

Item ID: D5548-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Window Retainer

Start Date: 9/1/2017 Start Qty: 25.00

25

Cust Item ID:

Required Date: 9/12/2017 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date:

SEP 01 2017

Tooling:

Date:

QC:

21

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5548

B3

100

0.00

100

BAND SAW

Bandsaw

Memo

0.23

Jeaspa Bandsaw

Cut Blanks at 5.83"

ONE BLANK MAKES 5 PARTS

D.P. 17-09-09

25

0

DAS
14
9-89

17/09/11

110

3.20

110

HAAS CNC VERTICAL MACHINING #1

HAAS 5AXIS

Memo

9.13

HAAS CNC vertical machine #5

1-Machine per folio FB556

DWG REV: B3

FOLIO REV: 00

D.P. 17-09-09

25

0

DAS
14
9-89

17/09/11

2- Deburr

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Item ID: D5548-1	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:				Stop	*NS2*
Item Name: Window Retainer					
Start Date: 9/1/2017	Start Qty: 25.00	*25*	Cust Item ID:		
Required Date: 9/12/2017	Req'd Qty: 25.00	*25*	Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120						<u>25</u>	<u>0</u>		DAS 14 17/09/11 9-89
QC	Memo	0.25							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									17-9-11
QC	Memo	0.50							
Quality Control									
140	Identify as per dwg & Stock Location:	0.00							
140									17-12-14
Packaging	Memo	0.25							
Packaging									

pulled for RD17-1019-01

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Item ID: D5548-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window Retainer
Start Date: 9/1/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 9/12/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	2.50							
Quality Control									

POSITIVE RECALL
EFFECTIVE **SEP 01 2017** AUTH **DAS 21**
RELEASED _____ DATE _____
RD17-1019-02

Picklist Print

Page 1

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Work Order ID: 165878

165878

Parent Item: D5548-1

D5548-1

Parent Item Name: Window Retainer

Start Date: 9/1/2017

Required Date: 9/12/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP REV:A 17.07.21 NEW ISSUE DD VERF:JFS
17.08.28 MATERIAL CHANGE DD VERF:JFS

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.500		Purchased		No		100	f	0.0000	0.097	2.552632			

M303R1 500

M303R1.500

→ M304 R1.500

→ M135559

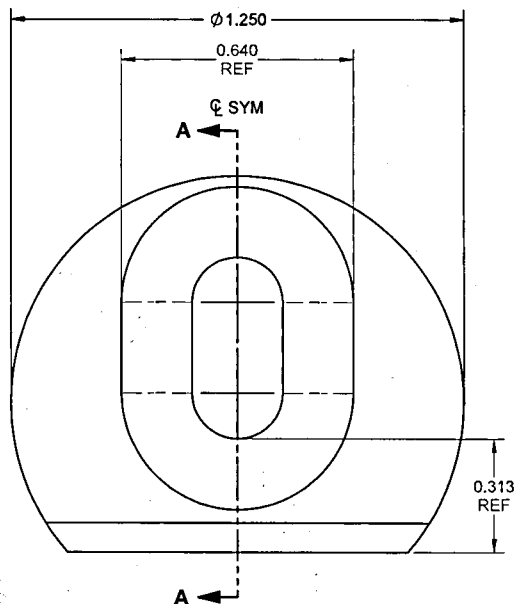
2.743^{ft}

only
17/09/11

issue 3675-1
5015844
*12

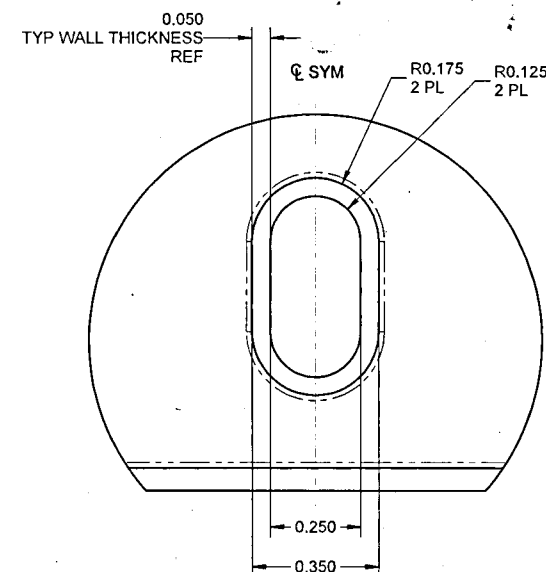
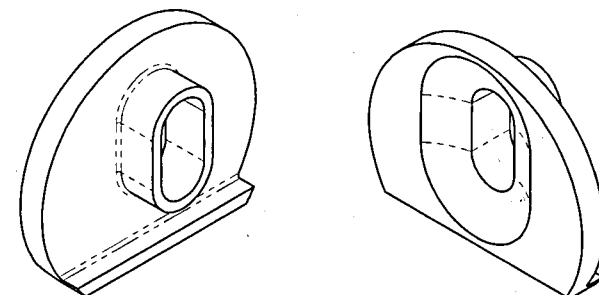
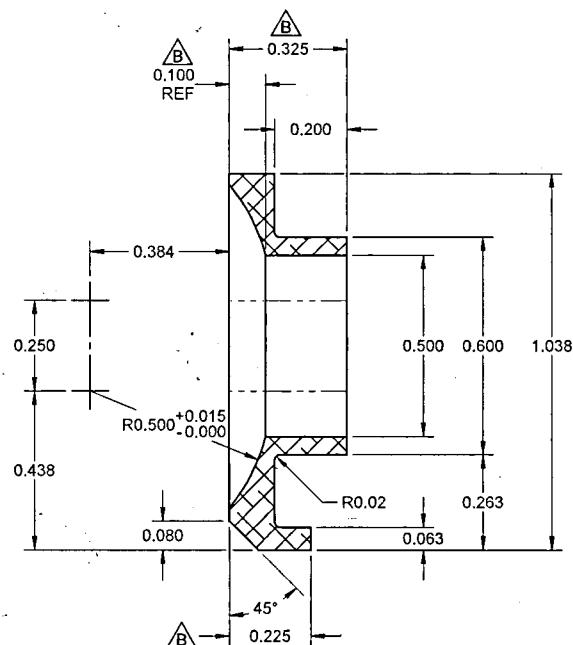
PI 12-794-03
✓
5013071

Acc. #
sect job



D5548-1 WINDOW RETAINER

- NOTES:**
- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
PER ASTM A582
REF DART SPEC M303R
OR: AISI 304/316 STAINLESS STEEL ROUND BAR
PER ASTM A276
REF DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.03 lbs



B	MATERIAL WAS BLACK DELRIN. WEIGHT WAS LESS THAN AND 0.01 LBS. ADD 0.100 REF DIM. 0.325 DIM WAS 0.300 AND 0.225 DIM WAS 0.200. REASON: DURABILITY.	AJS	17.07.25
A	NEW ISSUE	ML	17.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. B3
MFG. APPR.	JFS	D5548	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WINDOW RETAINER	NTS
DATE	17.07.25	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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